

Work Order ID 74259

Tuesday, September 27, 2011 1:07:59 PM



Page 1

Item ID:	D4131-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler Assembly					
Start Date:	9/27/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	10/6/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4131	B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
6061-063	1-Cut D4131 as per Dwg								
	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

B11-9-27

12

B11-9-27

12

Sub 1/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	COUNTER SINK AS PER DWG								
	Deburr if necessary.								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Signature 9/27/09/28 (12)

8/11/09/28

(12)

12 BL 11-9-28.

W/O:		WORK ORDER CHANGES						
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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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161 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

12x Ø M / 11/09/28

165

0.00



Small Fab Memo

0.00

Small Fab ASSEMBLE NUT PLATES AS PER DWG

9/31/10/03 (12)

166 QC5- Inspect part completeness to step on W/O

0.00



QC Memo

0.00

Quality Control

5/4/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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NOTE: Date & initial all entries



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Item Name: Doubler Assembly
Start Date: 9/27/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 10/6/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 132</u> Memo	0.00 0.00							
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Coety *12x* *11/10/3* *[Signature]*

11/10/5 *[Signature]*

11-10-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 74259

Parent Item: D4131-043

Parent Item Name: Doubler Assembly

Start Date: 9/27/2011

Required Date: 10/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

136.9456

0.1807

1.902105

2x5



6061-T6 .063 Sheet

13-11-9-27

Location

Loc Qty

Loc Code

MAT021

136.9455684

116308

26.9755684

117285

98.97

118580

11

117285

(12)

MS20426AD3-3

Purchased

No

165

Each

1,637.000

8

80



Rivet

ES 10/10/03

Location

Loc Qty

Loc Code

ST316

1637

19099

1637

96

MS21069L3

Purchased

No

165

Each

41.0000

4

40



ANCHOR NUT

ES 10/10/03

Location

Loc Qty

Loc Code

ST302

41

103447

1

115708

4

118003

36

39

7119108 (92)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

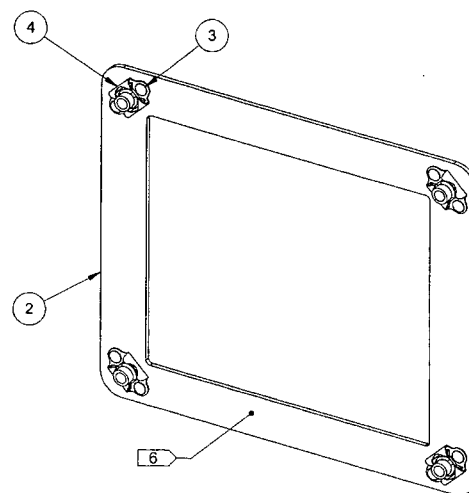
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	8	MS20426AD3-3	RIVET
4	4	MS21069L3	NUT PLATE



D4131-043 DOUBLER ASSEMBLY

RELEASED
2011-09-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 2 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MANIFOLD ASSEMBLY	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	